

Date: Wednesday, 2/8/2006 7:07:03 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	DOUBLER
<b>Job Number</b> :	25734		
<b>Estimate Number</b> :	11473		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D3140301
<b>This Issue</b> :	2/8/2006	<b>Drawing Number</b> :	D3140 REV C
<b>S.O. No.</b> :	N/A	<b>Project Number</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	C
<b>First Issue</b> :	N/A	<b>Material</b> :	N/A
<b>Type</b> :	MACHINED PARTS	<b>Due Date</b> :	2/15/2006
<b>Previous Run</b> :	N/A	<b>Qty:</b>	2
<b>Written By</b> :	SEE COMMENT BELOW	<b>Um:</b>	Each
<b>Checked &amp; Approved By</b> :	HL		
<b>Comment</b> :	Est. A02.11.06 New issue KJ/RF		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S063	6061-T6 .063 Sheet
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**Comment:** Qty.: 2.9166 sf(s)/Unit Total: 5.8332 sf(s)  
 6061-T6 .063 Sheet  
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick(  
 M6061T6S.063)  
 Batch: M18556  
 Identify as D3140-301

ml 06/02/13

2.0	SHEAR	SHEAR
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**Comment:** SHEAR  
 Cut blanks: 48.700" x 7.350"

ml 06/02/13

(2)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine D3140-301 as per Folio FA316 and Dwg D3140  
 Deburr

make by hand

ml 06/02/16

(2)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

N/A

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

26-02-17 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *DD*   Date:   06/02/20  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/8/2006 7:07:04 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 25734

Part Number: D3140301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF

06-02-27

(2)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

161 06 02 17

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

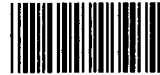
C 206102117

(2)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

510 06/02/20

(2)

06/02/20

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries